

Work Order ID 55856

February 3, 2010 12:49:42 PM

Page 1

Item ID: D4003-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Vent Line Lower

Start Date: 2/03/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *PL* Date: *10-2-03*

Tooling:

Date:

QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4003

A-PRELIM

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut tube xxx" long

2- Bend as per dwg

0.00

110

QC5- Inspect part completeness to step on W/O



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1



HandFinish

Memo

0.00

Hand Finishing

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55856

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Page 2

Item ID:	D4003-11	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Vent Line Lower					
Start Date:	2/03/10	Start Qty:	1.00			
Required Date:	2/10/10	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: <u>110</u>	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL
EFFECTIVE 03-10 AUTH U
RELEASED J DATE 10-2-19

10/09/01
10-2-19
1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 12:49:48 PM

Page 1

Work Order ID: 55856



Parent Item: D4003-11



Parent Item Name: Vent Line Lower

Start Date: 2/03/10

Required Date: 2/10/10

Comments: IPP rev A 10.01.12 new issue prelim EC verified by:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.035		Purchased	No			100	f	479.3559	1.9700			
6061-T6 RD Tube .500 x.035W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

4692

479.3559

479.3559

10/02/10

m-d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

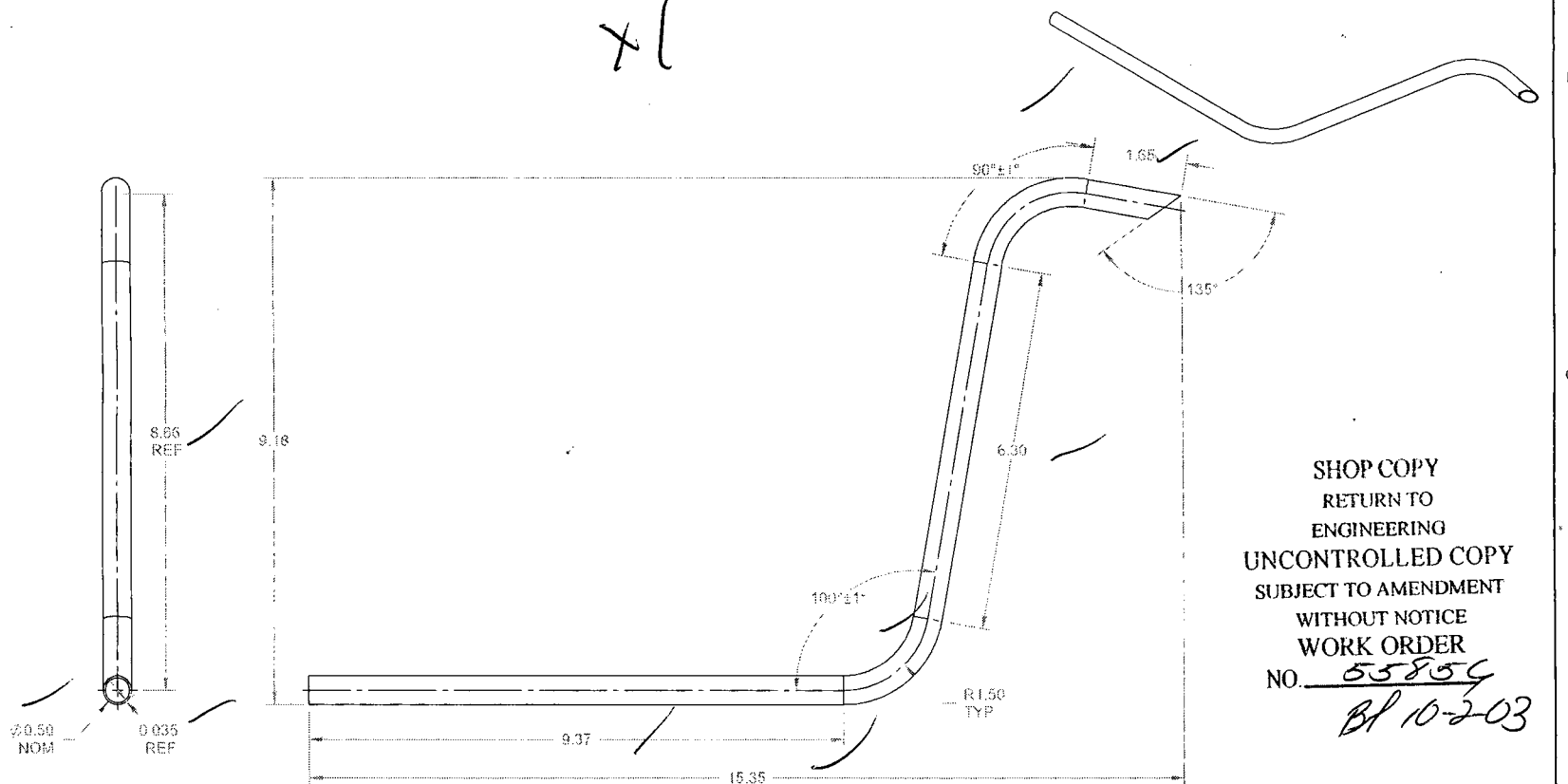
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-11	JCA-M47-2-21



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55854
BL 10-2-03

See Rev. A.

D4003-11 VENT LINE LOWER

PRELIMINARY ISSUE

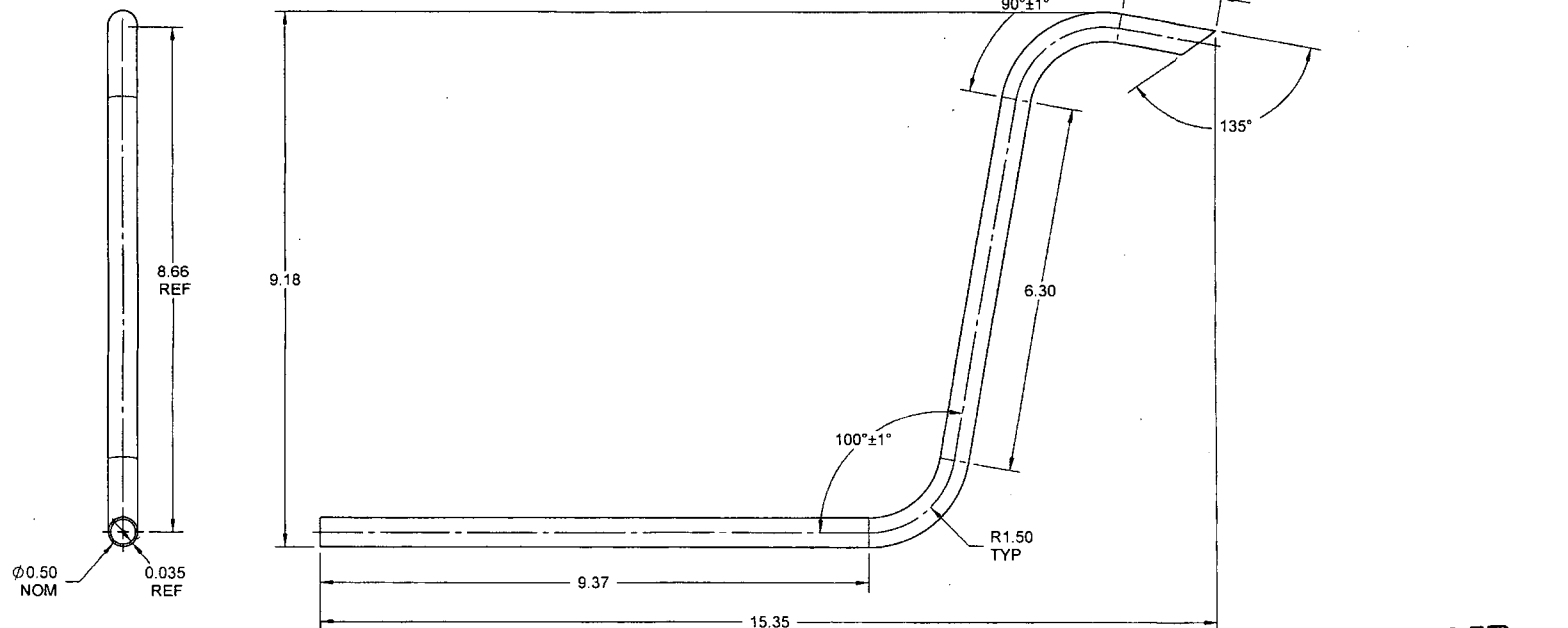
09.10.15

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.500 \times 0.035$ WALL THICKNESS
PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4003	REV. PA1
MFG. APPR.	<i>[Signature]</i>	TITLE LINE	SHEET 8 OF 9
APPROVED		SCALE	NTS
DE APPR.			
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-11	JCA-M47-2-21



D4003-11 VENT PIPE - TANK

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.500 \times 0.035$ WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4003	REV. A
MFG. APPR.			SHEET 8 OF 9
APPROVED		TITLE LINE	SCALE
DE APPR.			NTS
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55856R RELEASED
2010-05-05
MP